

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004714**Date Inspected:** 07-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Erik Prue was present to perform Ultrasonic Testing (UT) and Radiographic film review of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Assembly:

QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. This inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP271-001, 3 ribs, 6 welds, 156 total tack welds. Weld 1 scanned 26 locations with 3 indications, weld 2 scanned 26 locations with 4 indications, weld 3 scanned 26 locations with 11 indications, weld 4 scanned 26 locations with 2 indications, weld 5 scanned 26 locations with 3 indications, weld 6 scanned 26 locations with 4 indications, Please see U-rib Deck Panel Tack Weld Assessment report dated 07 November, 2008 for specific locations of indications.

QA inspector performed UT on deck panel DP164-001, 5 ribs, 10 welds, 260 total tack welds. QA UT inspection was performed on welds 6 through 10 with 16 indications marked on top of U-rib. Welds 1 through 5 still need UT inspection and will be completed on swing shift.

No other activities observed.

Summary of Conversations:

No significant conversations this day.

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dauterman, 15002199593, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
